

Work Order ID 164039

Tuesday, July 11, 2017 1:57:33 PM

164039

Page 1

Item ID: D4273-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/31/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 11 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4273

F

D4279

B

100

Weld per dwg A/R S.S. rod Batch **M135088** 0.00***100***

Large Fab

Large Fab

Memo

3.16

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

1x CC 17-7-27

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/17/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/31/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NB1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

-Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per OSI 044 6.4

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.54

Hand Finishing

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Page 3

Item ID: D4273-042 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Basket Base Assembly, RH
Start Date: 7/17/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 7/31/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo *M/138014* 0.64

1- Plug holes and mask only interior of hinge (3) prior to powder coat

2-Mask this area prior to finish View AK-AK

1ST COAT:

START TIME: *11:45*

OVEN TEMPERATURE: *375°*

FINISH TIME: *12:00*

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 *φ* *1707-81* **DAS 34 9-89**

140	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

0.01

1x *φ* *17/08/02* **DAS 15 9-89**

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Item ID: D4273-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/31/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: w/o

0.00

D4272-012/B164035

150

Packaging

Memo

0.01

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.10

Quality Control

DAS
21
9-89

AUG 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Tuesday, July 11, 2017 1:57:33 PM

Page 1

Work Order ID: 164039

164039

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017

Required Date: 7/31/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC IPP Rev:B
11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03
AS PER DWG REV.D DD verf:EC IPP Rev:D 12.07.24 AS PER
DWG REV.E DD VERF:EC IPP Rev:E 17.06.26 As per Dwg.RevF.
DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4672-1		Manufactured	No			100	Each	26.0000	2	2			DAS
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	-----

✓ *D4672-1* -

Blanking Plate

**

43 JUL 21 2017

Location	Loc Qty	Loc Code
----------	---------	----------

WA004	26	
161868	10	
163701	16	

2

M304EX0.75-16F

Purchased

No

100

sf

458.5000

32

32

M304FX0 75-16F

Expanded Metal Flat SS

**

4137765 → 32006 JUL 21 2017

Location	Loc Qty	Loc Code
----------	---------	----------

WA004	458.5	
M137294	11.5	
M137765	447	

D3913-1

Manufactured

No

100

Each

3.0000

1

1

✓ *D3913-1*

Rib

**

DAS
43
JUL 21 2017

Location	Loc Qty	Loc Code
----------	---------	----------

WA004	3	
162728	3	

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

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Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017

Required Date: 7/31/2017

Start Qty: 1.00

Required Qty: 1.00

✓ ***D3913-3***
Rib

Manufactured	No	100	Each	5.0000	1	1	DAS 43 9-89	JUL 21 2017
				**				

✓ ***D3913-9***
Hinge Rib

Manufactured	No	100	Each	5.0000	1	1	DAS 43 9-89	JUL 21 2017
				**				

✓ ***D3916-5***
Light Rib

Manufactured	No	100	Each	4.0000	3	3	DAS 43 9-89	JUL 21 2017
				**				

✓ ***D4017-7***
Rib

Manufactured	No	100	Each	20.0000	3	3	DAS 43 9-89	JUL 21 2017
				**				

✓ ***D4277-3***
Rib

Manufactured	No	100	Each	0.0000	1	1	DAS 43 9-89	JUL 25 2017
				**				

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Shop Packet Print

Page 2

DQA: _____ Date: _____

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								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Picklist Print

Tuesday, July 11, 2017 1:57:33 PM

Page 3

Work Order ID: 164039

164039

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017

Required Date: 7/31/2017

Start Qty: 1.00

Required Qty: 1.00

D4277-5 Manufactured No

100 Each

0.0000

2 2

DAS

✓ *D4277-5* -

Rib

**B163977 → 2x DAS 43 JUL 21 2017 9-89

D4277-9 Manufactured No

100 Each

3.0000

1 1

DAS

✓ *D4277-9*

Rib

**B146419 → 1x DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

3

146419

3

D4277-19 Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D4277-19* -

Rib

**B161129 → 1x DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

1

151129

1

D4278-041 Manufactured No

100 Each

2.0000

1 1

DAS

✓ *D4278-041* -

Upper Rib Assembly-Hoop

**B158899 → 1x DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

2

158899

2

D4278-045 Manufactured No

100 Each

0.0000

2 2

DAS

D4278-045

Rib Assembly, Fwd Cham

**B164524 → 2x DAS 43 JUL 21 2017 9-89

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Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

Tuesday, July 11, 2017 1:57:33 PM

Page 4

Work Order ID: 164039

164039

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017

Required Date: 7/31/2017

Start Qty: 1.00

Required Qty: 1.00

D4278-047

Manufactured No

100

Each

2.0000

1 1

DAS

✓*D4278-047*

Upper Rib Assembly-Straight

**B158905 → 1x DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

2

151034

1

158905

1

D4306-1

Manufactured No

100

Each

3.0000

1 1

DAS

✓*D4306-1*

Rib

** DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

3

146250

2

146425

1

D4306-044

Manufactured No

100

Each

1.0000

1 1

DAS

✓*D4306-044*

Rib Assembly, RH

**B58894 → 1x DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

1

158894

1

D4306-045

Manufactured No

100

Each

1.0000

1 1

DAS

✓*D4306-045*

Rib Assembly

**B158041 → 1x DAS 43 JUL 21 2017 9-89

Location

Loc Qty

Loc Code

WA004

1

154041

1

Tuesday, July 11, 2017 1:57:33 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, July 11, 2017 1:57:33 PM

Page 5

Work Order ID: 164039

164039

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017

Required Date: 7/31/2017

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No

100 Each

58.0000 2 2

DAS
43 JUL 21 2017
9-89

✓ *D2581* -
Mounting Bracket

**

Location

Loc Qty

Loc Code

WA004

58

161800

18

162923

40

163743 2

D3913-15 Manufactured No

100 Each

31.0000 1 1

DAS
43 JUL 21 2017
9-89

✓ *D3913-15* -
Wide Handle Plate

**

Location

Loc Qty

Loc Code

WA004

31

161938

31

1

D4016-1 Manufactured No

100 Each

70.0000 3 3

DAS
43 JUL 21 2017
9-89

✓ *D4016-1* -
Hinge Half, Base

**

Location

Loc Qty

Loc Code

WA004

70

158630

3

159537

67

3

D4021-1 Manufactured No

100 Each

40.0000 3 3

DAS
43 JUL 21 2017
39

✓ *D4021-1* -
Handle Plate

**

Location

Loc Qty

Loc Code

WA004

40

161473

13

161900

27

3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER : _____																									

Picklist Print

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Page 6

Work Order ID: 164039

164039

Parent Item: D4273-042

D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/17/2017

Required Date: 7/31/2017

Start Qty: 1.00

Required Qty: 1.00

D4279-5 Manufactured No

100

Each

3.0000

1 1

D4279-5

End Mesh, Basket

**** B157486 → 1x 43 DAS JUL 21 2017**
9-89

Location

Loc Qty

Loc Code

WA006

3

142685

2

157486

1

D4279-7 Manufactured No

100

Each

6.0000

2 2

D4279-7

End Mesh, Basket

**** B157506 → 2x 43 DAS JUL 21 2017**
9-89

Location

Loc Qty

Loc Code

WA006

6

154304

2

157506

4

D4279-9 Manufactured No

100

Each

3.0000

1 1

D4279-9

End Mesh, Basket

**** B157632 → 1x 43 DAS JUL 21 2017**
9-89

Location

Loc Qty

Loc Code

WA006

3

151140

1

157632

2

Tuesday, July 11, 2017 1:57:33 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



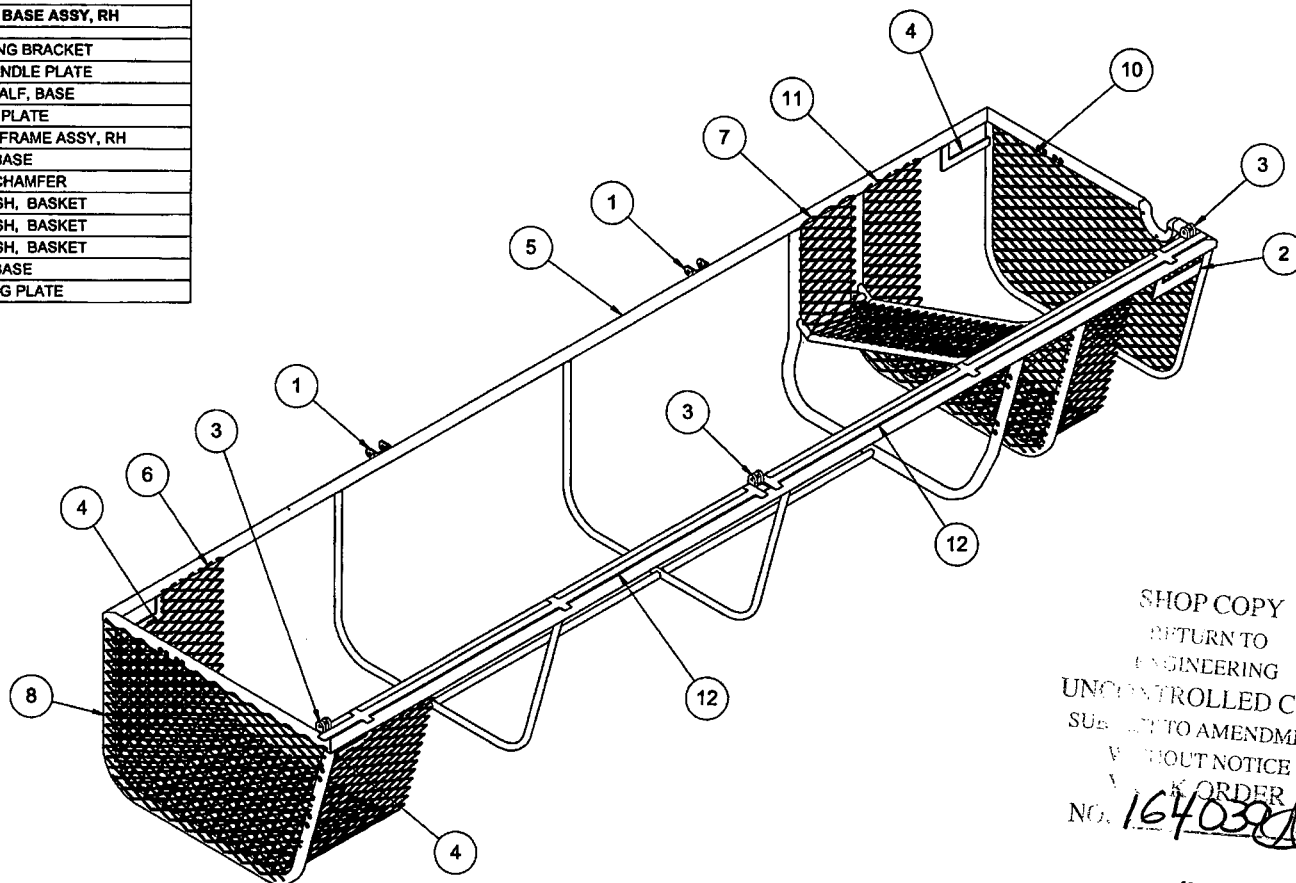
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE
12	2	D4672-1	BLANKING PLATE



D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.
- 11) MASK THIS AREA PRIOR TO FINISH

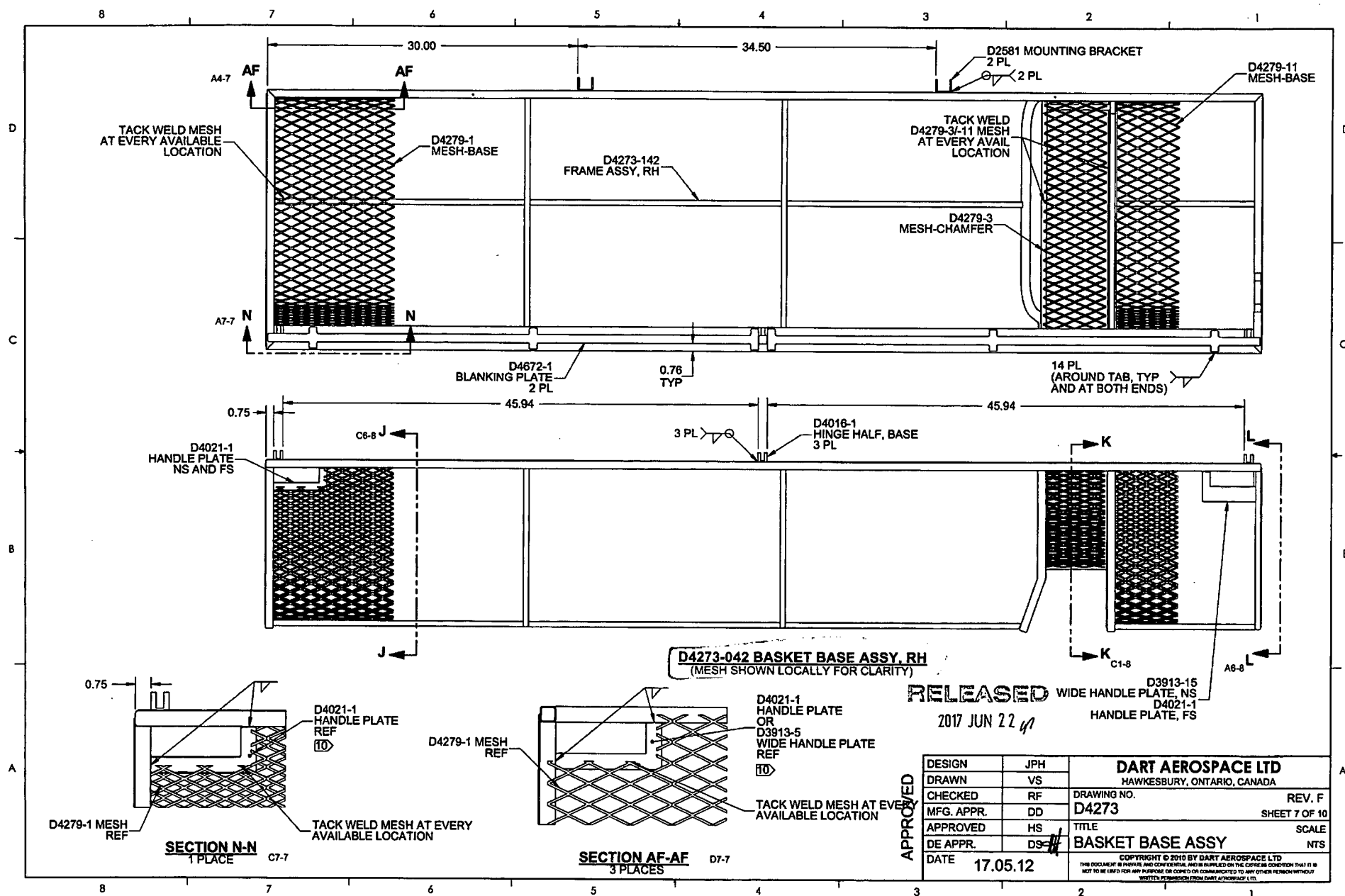
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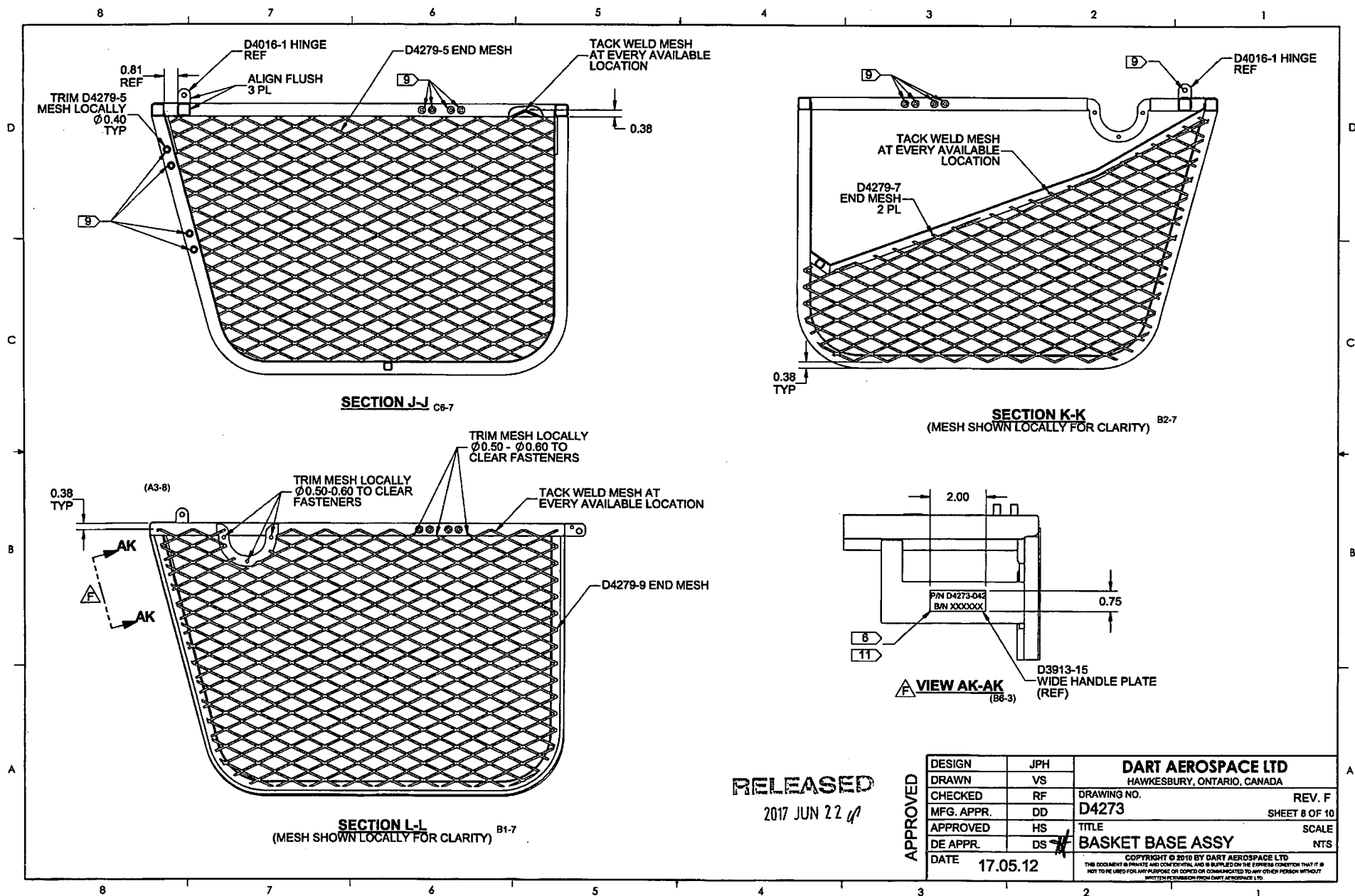
2017 JUN 22 *41*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *16403210*

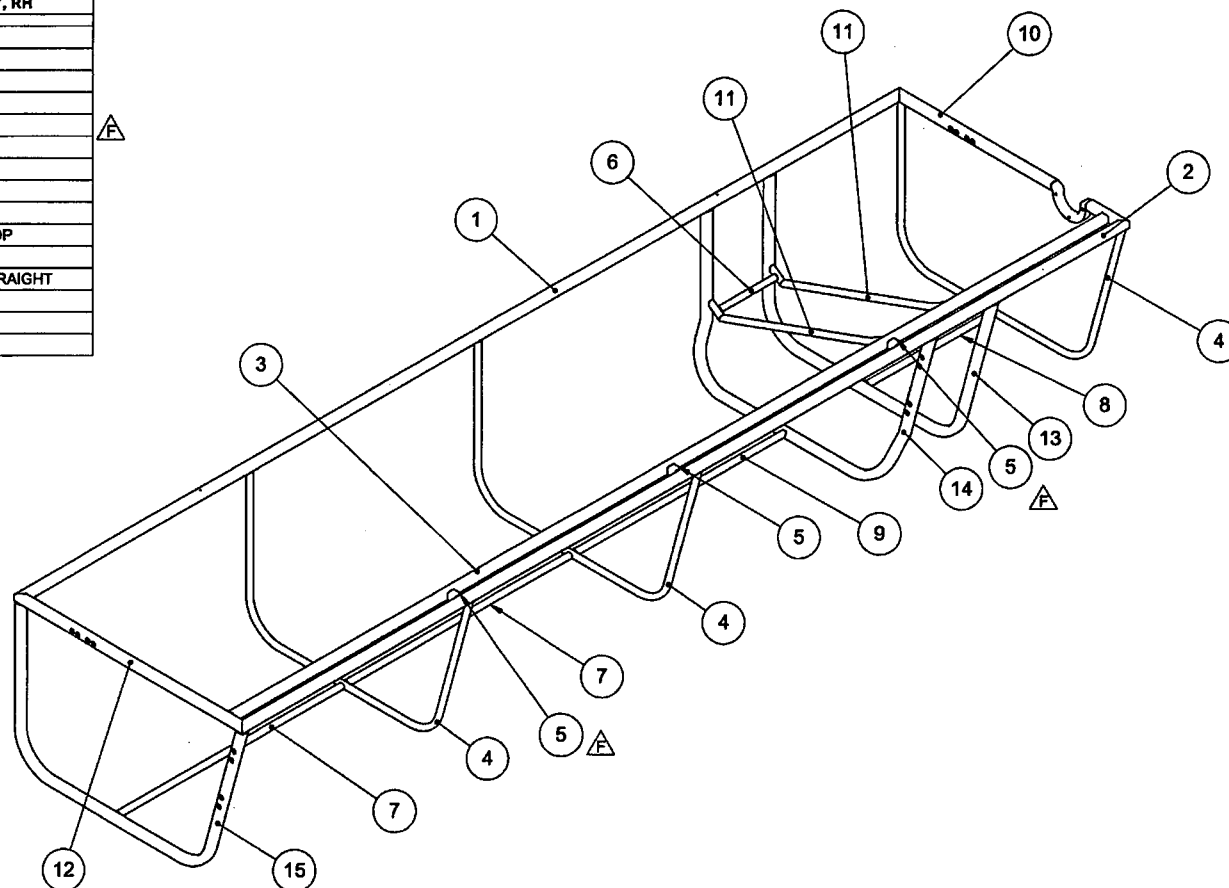
JUL 11 2017

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D4273	SHEET 6 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
DATE	17.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	3	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY - STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY
15	1	D4306-045	RIB ASSY



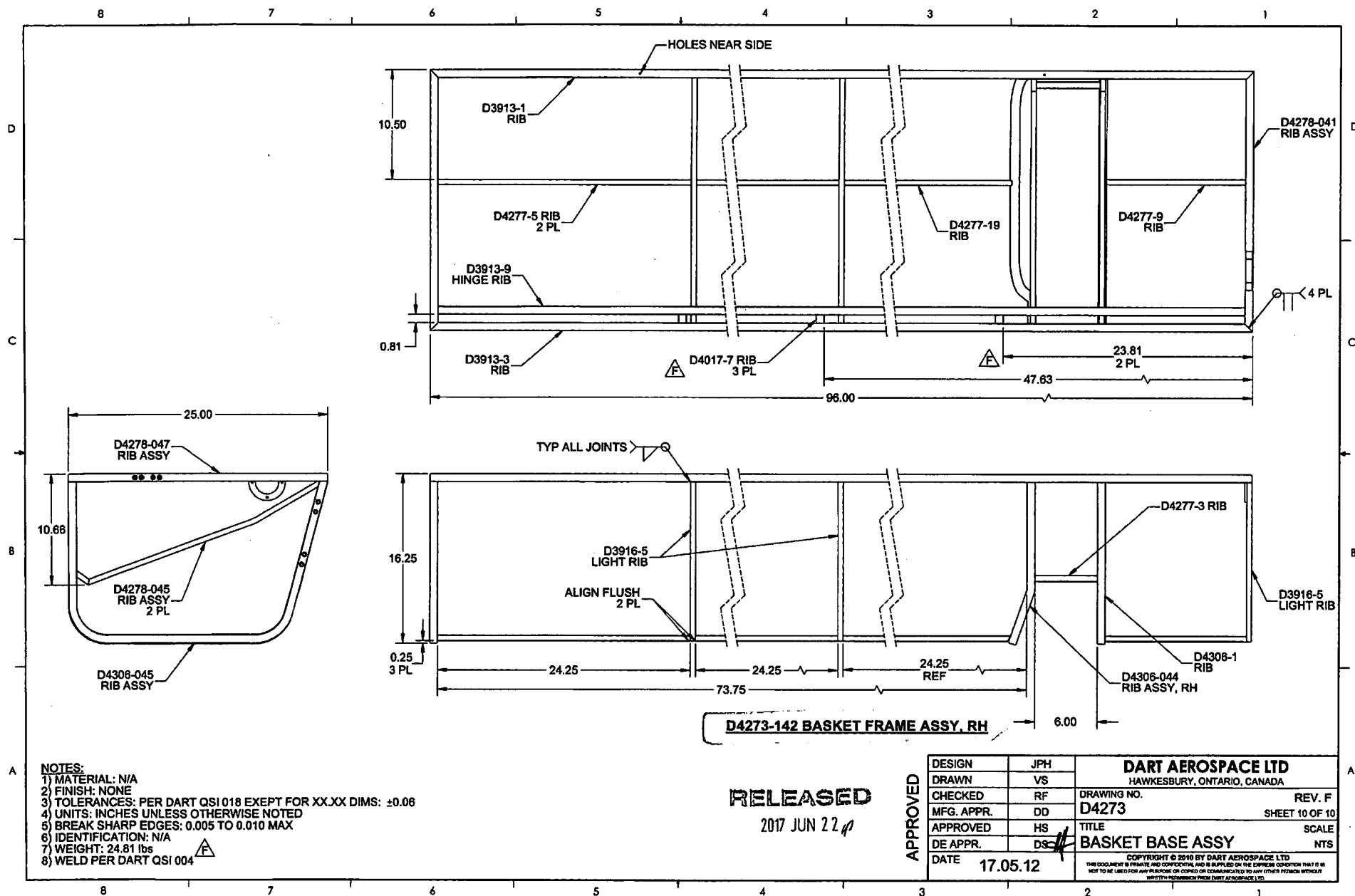
D4273-142 BASKET FRAME ASSY, RH

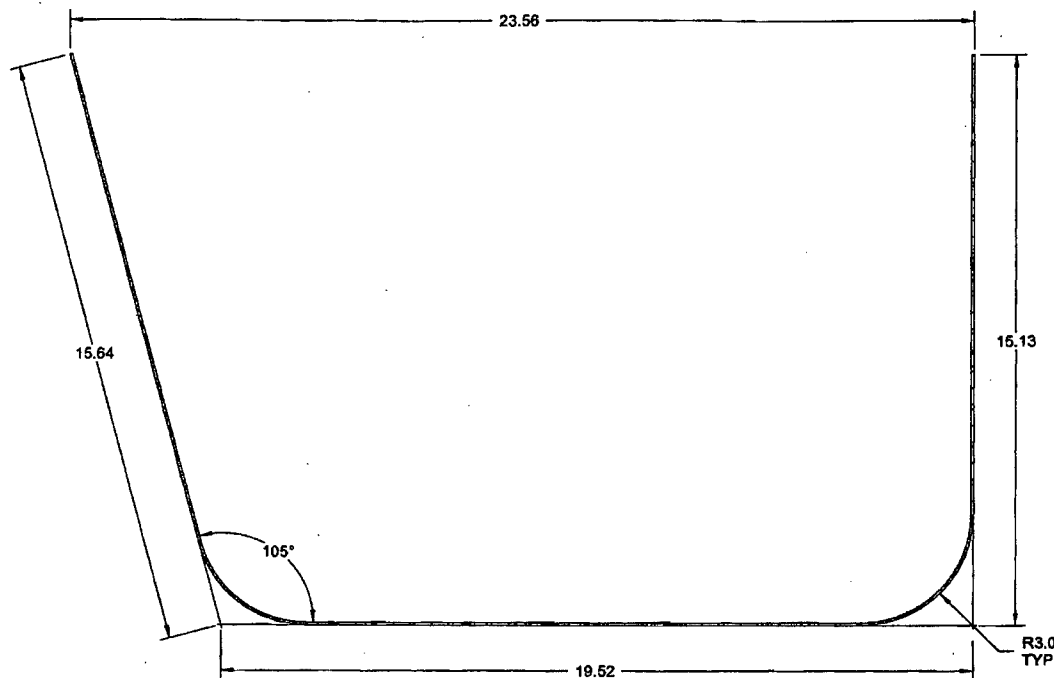
RELEASED

2017 JUN 22 *pp*

APPROVED

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D4273	SHEET 9 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
DATE	17.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4279-1 MESH - BASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1641039
JUL 11 2017

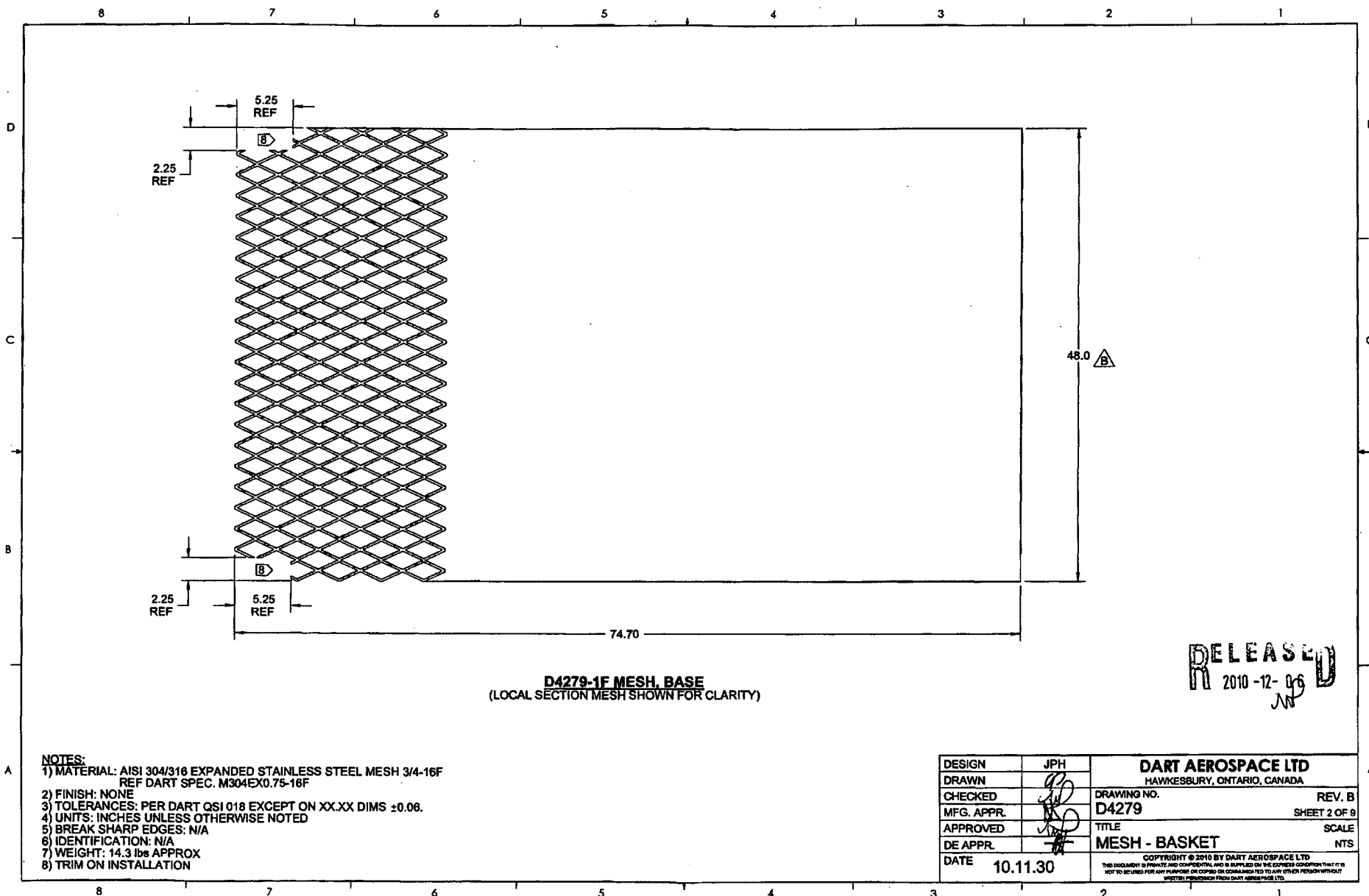
RELEASED
2010-12-06
MD

NOTES:

- 1) MATERIAL: MAKE FROM D4279-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-1F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

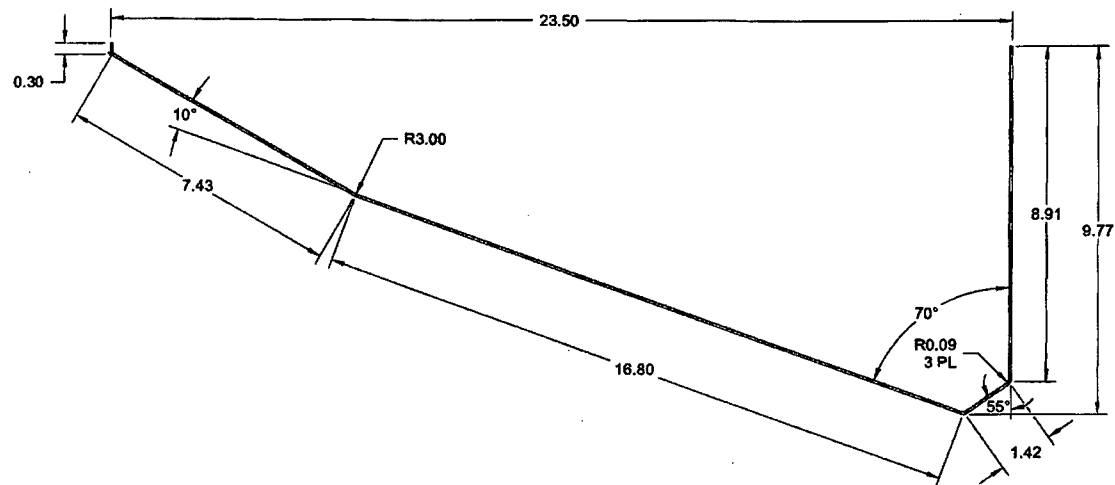
B	-3F: 6.50 WAS 20.00 (BS-4); REDESIGN -9 (SHT 7); ADD -11/-11F (SHT 8/9); 48.0 WAS 50.50 (C2-2, C7-6); CUTOUTS ON -3 NOW TRIMMED ON INSTALL (AS-4)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.11.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
DRAWING NO.	D4279	SHEET 1 OF 9
TITLE	MESH - BASKET	SCALE
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JN

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4279	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
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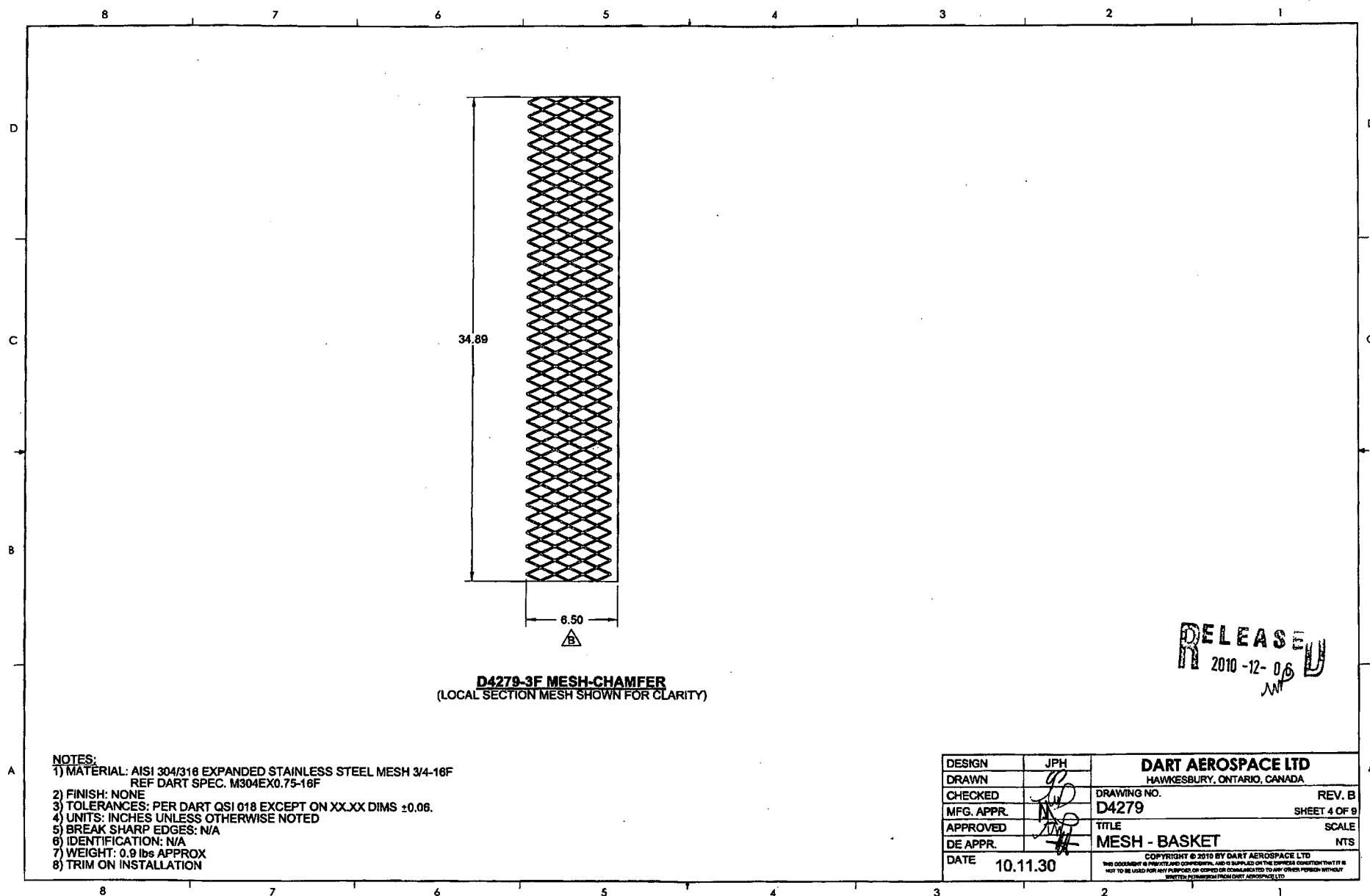
D4279-3 MESH-CHAMFER

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2010-12-06

NOTES:

- 1) MATERIAL: MAKE FROM D4279-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-3F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4279	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
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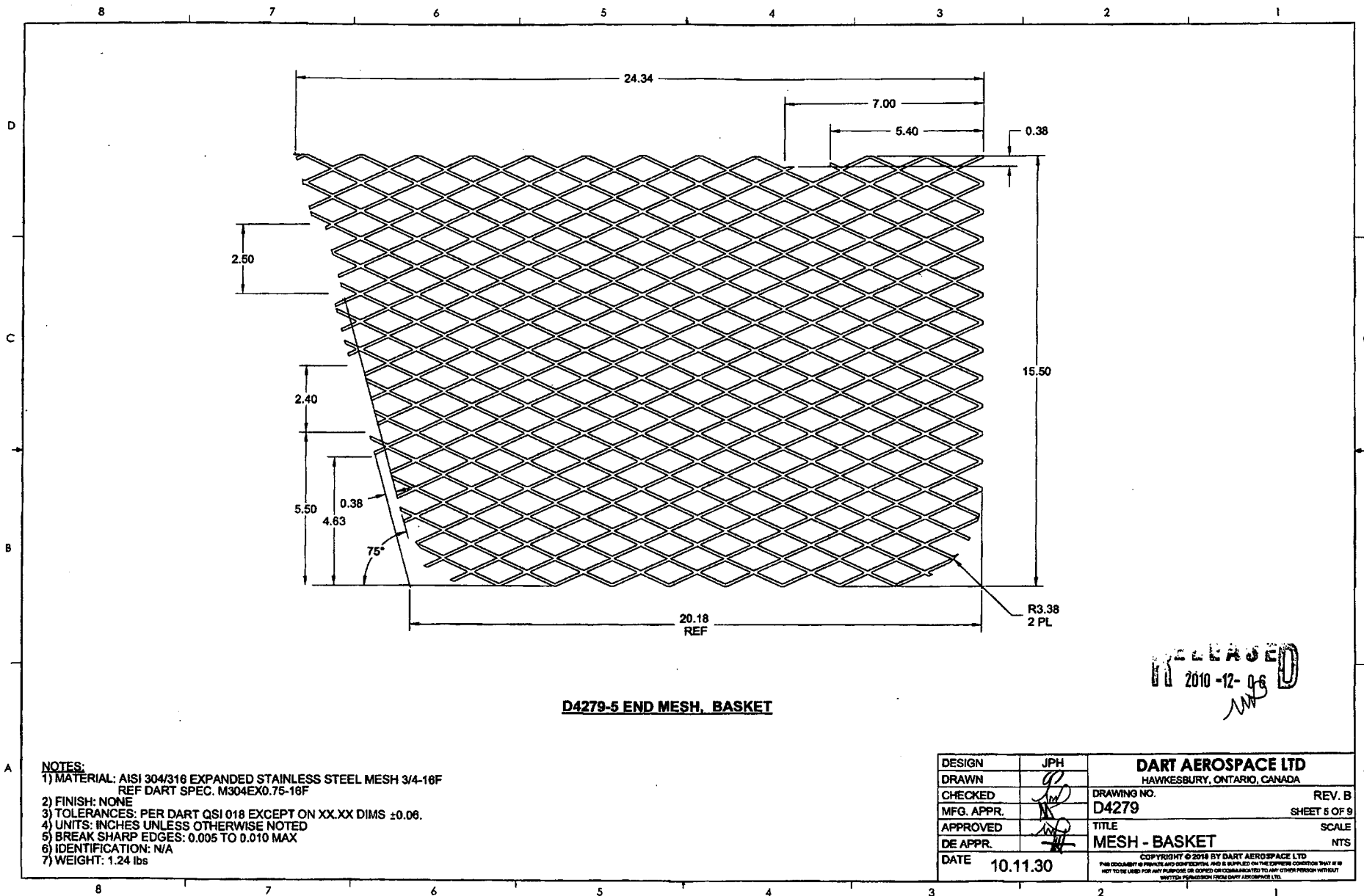


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2010-12-06
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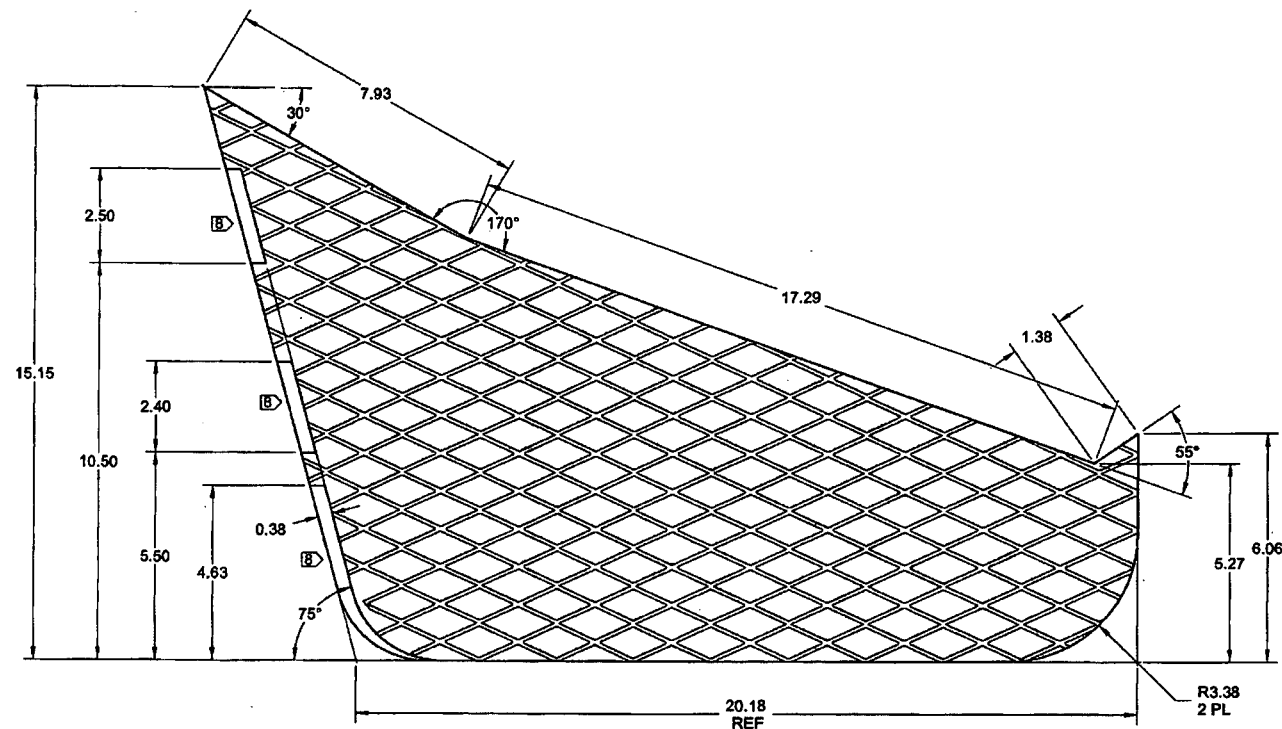
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.9 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4279	SHEET 4 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
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D4279-7 END MESH. BASKET

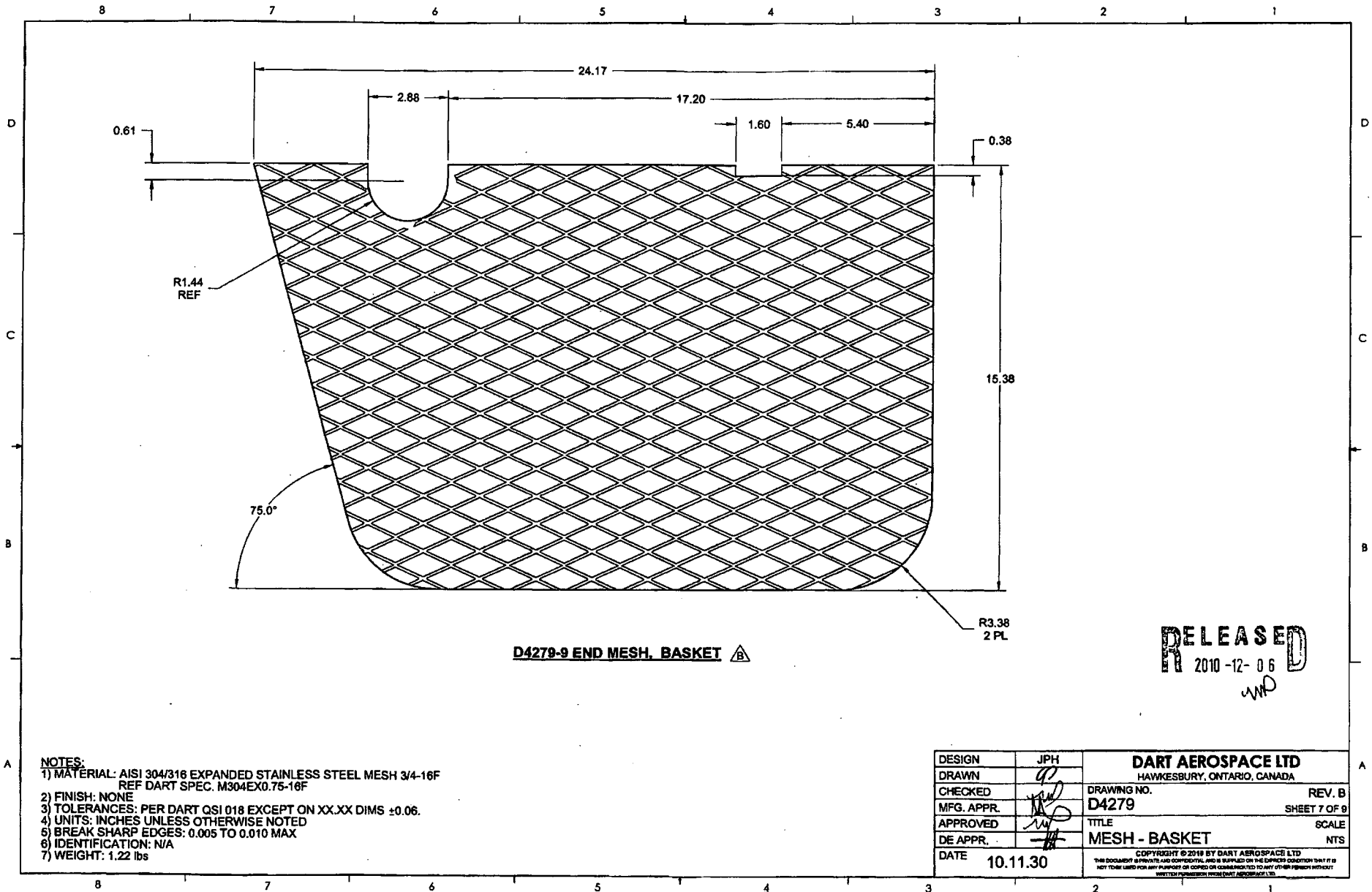
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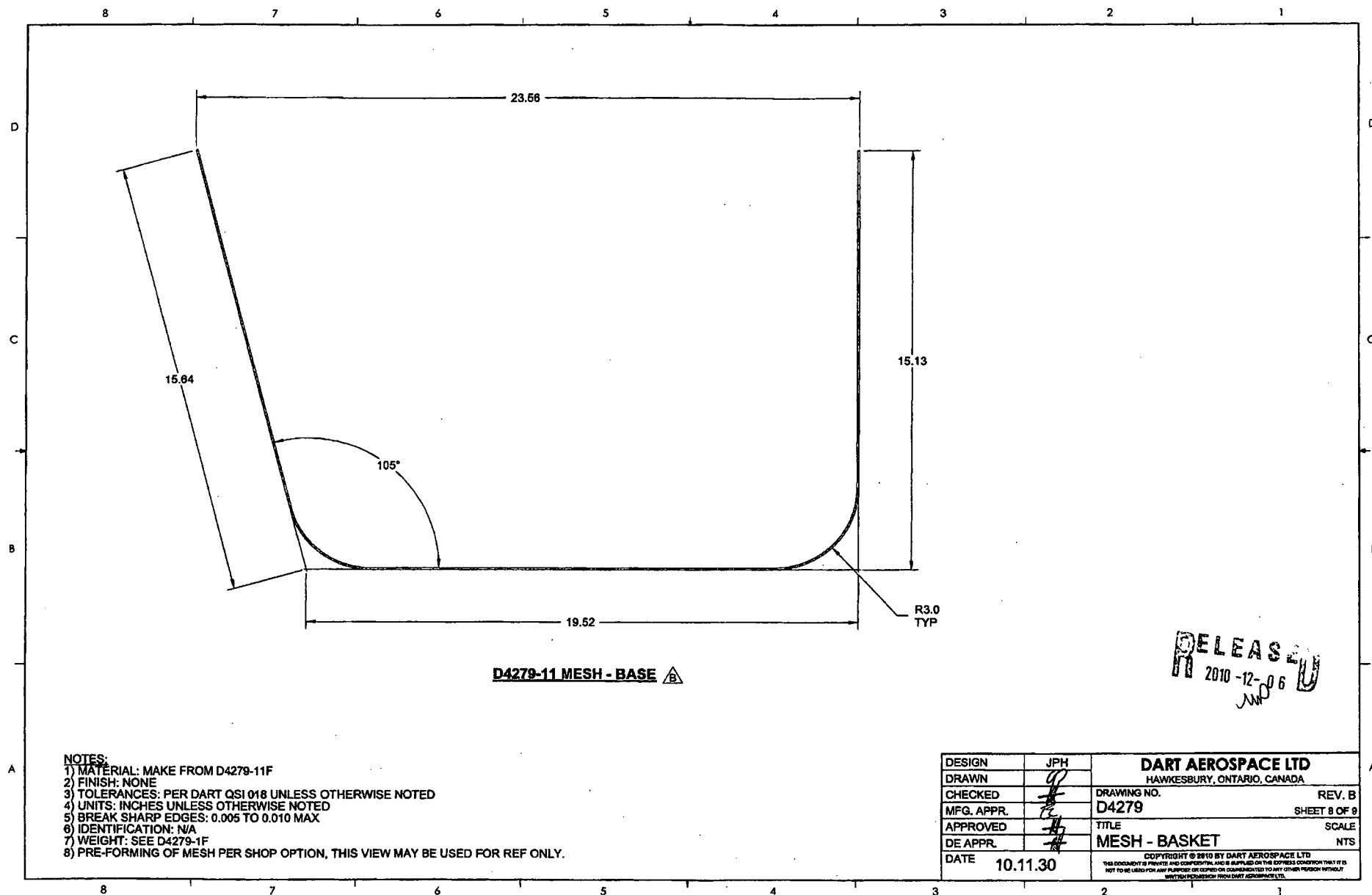
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XX.XX DIMS ±0.06.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs
- 8) TRIM ON INSTALLATION TO CLEAR HOLES (IF PRESENT)



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JB	D4279	SHEET 6 OF 8
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MESH - BASKET	NTS
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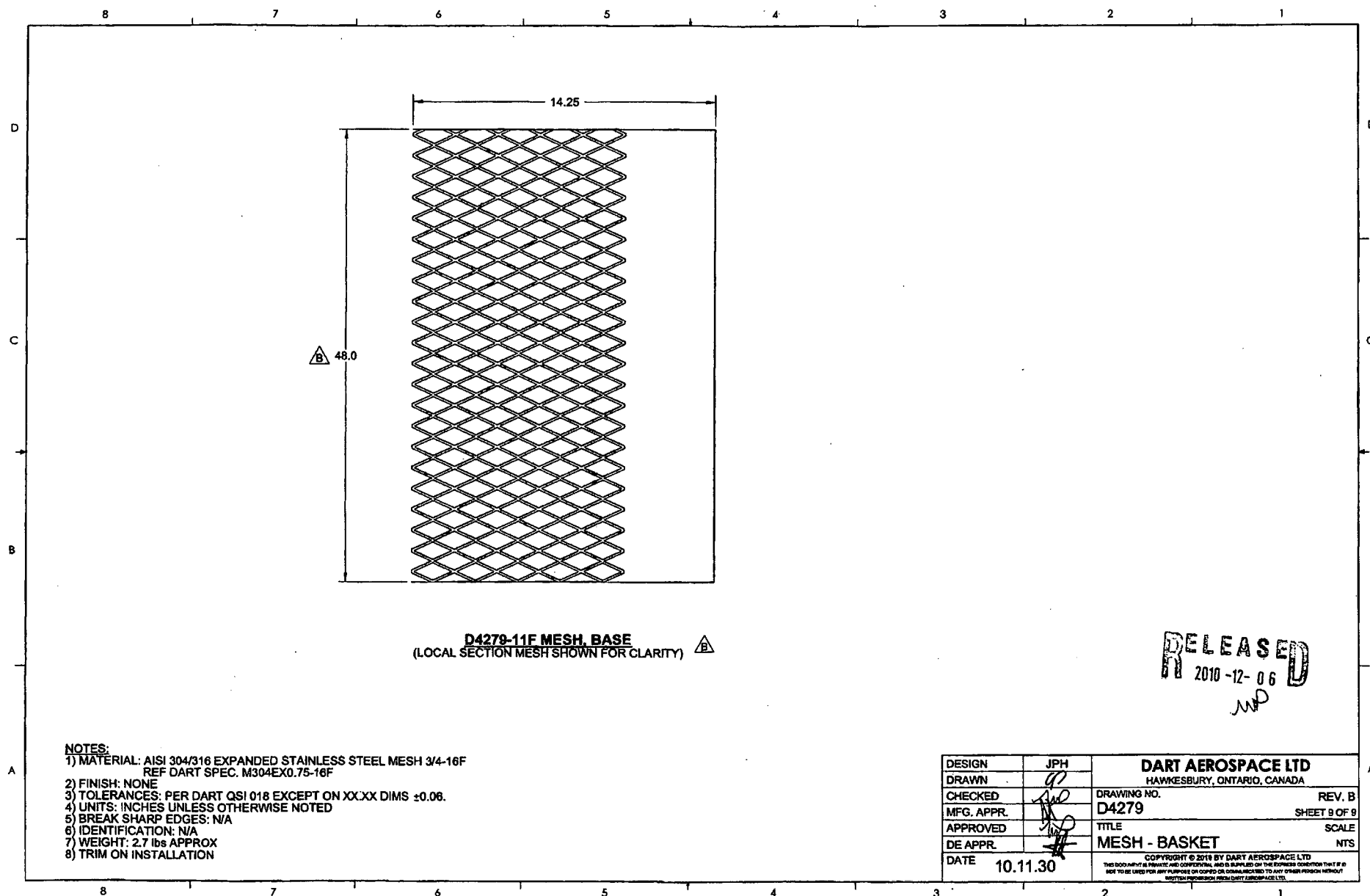


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NOTES:

- 1) MATERIAL: MAKE FROM D4279-11F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4279-1F
- 8) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4279	SHEET 8 OF 9
APPROVED		TITLE	SCALE
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NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 EXCEPT ON XXXX DIMS ± 0.06 .
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.7 lbs APPROX
- 8) TRIM ON INSTALLATION

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4279	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 9 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MESH - BASKET	NTS
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